

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019930**Date Inspected:** 27-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	Mr. Wang Jie.		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Orthotropic Box Girder (OBG) Bay 14~16**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY # 14:

Flux Cored Arc Welding (FCAW) welding of welds joint AP3020-001-014,015, and Welder is identified as 201215,202122. ABF Quality Control (QC) is identified as Mr. Shao Jian Yuan. The welding variables appeared to comply with the Applicable WPS-B-T-2132.

FCAW welding of Base metal Buildup for Miss cutting area(Plate BP3070A 13CW) , And Critical Welding Repair Report(CWR) B-CWR1911,Welder is identified as 066746. ZPMC Quality Control (QC) is identified as Mr. Wang Jie. The welding variables appeared to comply with the Applicable WPS-345-FCAW-1G(1F)-FCM-Repair.

FCAW welding of welds joint VP3016-001-013,And Welder is identified as 066763, ZPMC Quality Control (QC) is identified as Lv Li Qing. The welding variables appeared to comply with the Applicable WPS-B-T-2232-TC-U4b-F.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Submerged Arc Welding (SAW) welding of welds joint SEG3014-004, and Welder is identified as 045270. ABF Quality Control (QC) is identified as Mr. Lv Yun. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2.

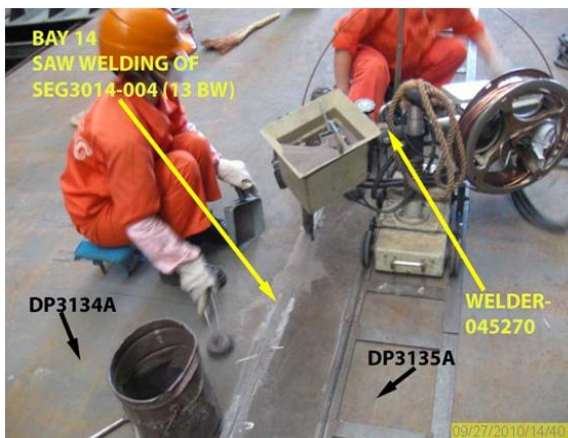
BAY#16

FCAW welding of welds joint LD3035-001-023(13BW), Welder is identified as 045143. ABF Quality Control (QC) is identified as Mr. LLi Shi You. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U5-F.

FCAW welding of welds joint LD3033-001-037(13CW), Welder is identified as 045280. ABF Quality Control (QC) is identified as Mr. LLi Shi You. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U5-F.

FCAW welding of welds joint LD3032-001-032(13BW), Welder is identified as 040344. ABF Quality Control (QC) is identified as Mr. LLi Shi You. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U5-F.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Tharikoppada,Reddy

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer